



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4435-043
Job Sheet 169596



Part No: D4435-043

Job Qty: 6 ea

Part Name: Mount Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B SHEETS 2,5 IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC IPP REV:B 12.03.06 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/11/18	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	6 pcs		1/11/18	0.07	0.43	Waterjet1		SC
110	QC	6 pcs		1/11/18	0.00	0.00	QC2 Waterjet-3		SC DAS
120	QC	6 pcs		1/11/18	0.00	0.00	QC8-4		38
130	HandFinish	6 pcs		1/11/18	0.00	0.28	HandFinish1		24/8/10/10/2/11
135	QC	6 pcs		1/11/18	0.00	0.00	QC7-3		BR 18-01-9
140	Powdercoat	6 pcs		1/11/18	0.00	0.14	Powdercoat4		BR 18-01-9
150	QC	6 pcs		1/11/18	0.00	0.00	QC3		38
160	Small Fab	6 pcs		1/12/18	0.00	0.83	Small Fab-6		FF 9-86
170	QC	6 pcs		1/12/18	0.00	0.00	QC5		24-18-1-10
190	Packaging	6 pcs		1/12/18	0.00	0.00	Packaging3-2	ST011	AT 18-01-10
200	QC21-SA	6 Ea		1/12/18	0.00	0.00	QC21		

M 135418

STAR: 1.55

OUT: 300' FINISH: 2.25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040	0	307	0	0
160-Small Fab	D4441-1	2	207	0	0

5018292

Part Specifications

Specifications could not be found.

Plex 12/14/17 11:28 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																							
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																					
Description Work Order Deviation			Disposition																																						
Change No: Operation: Revision: PART NO: Start up Operation Mfg Date: 12/19/17 Job No: 169596 D4435 - 043					Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																				
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td></tr> </table>		Environment	☐	No Re-verification	Design	☐	Operator	Doc/Data	☐	Offset/Setup	Equip/Tooling	☐	Supplier	Handling/Pre	☐	Training	Material	☐	Use for Testing	Internal Transport	☐	Poor Information	Tribal Knowledge	☐	Rushing	LOA	☐	Product Improvement	Substation	☐	Process Improvement	Past Expiry Date	☐	Manufacturing Process	Misidentified	☐	Past Due	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence Mount Bracket Assembly PART NO: D4435 - 043 Operation: Start up Operation Revision: Mfg Date: 12/19/17 Change No: Job No: 169596 S025313 DART AEROSPACE			
Environment	☐	No Re-verification																																							
Design	☐	Operator																																							
Doc/Data	☐	Offset/Setup																																							
Equip/Tooling	☐	Supplier																																							
Handling/Pre	☐	Training																																							
Material	☐	Use for Testing																																							
Internal Transport	☐	Poor Information																																							
Tribal Knowledge	☐	Rushing																																							
LOA	☐	Product Improvement																																							
Substation	☐	Process Improvement																																							
Past Expiry Date	☐	Manufacturing Process																																							
Misidentified	☐	Past Due																																							
OTHER : _____		Wave/Twist in Tube Marks/Chatter Cut too Short Instructions Incomplete/Unclear Drill Holes Mislabeled Fit/Function Misaligned/off center																																							

DART AEROSPACE LTD		Work Order:	169596
Description: Mount Bracket Assembly		Part Number:	4435-043
Inspection Dwg: 4435 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2,650	+/- 0,010	2,652	1		VR-02	
1,53	+/- 0,030	1,537	1			
0,35	+/- 0,030	0,356	1			
1,80	+/- 0,030	1,808	1			
2,64	+/- 0,030	2,647	1			
3,65	+/- 0,030	3,654	1			
0,850	+/- 0,010	0,855	1			
0,004	+0,005 -0,001	0,006	1			
2,15	+/- 0,030	2,147	1			
0,350	+/- 0,010	0,352	1			
0,650	+/- 0,010	0,654	1			

Measured by: SC	Audited by: 38	Preliminary Approval:
Date: 17/12/19	Date: DEC 27 2019	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4435-043 Revision: Mount Bracket Assembly														
200	QC21-SA	S025313	169596	6 Ea	0	S025313	ST091		Stock	12/19/2017	Issue Container			
Operation Totals:		1		6	0									
Part Totals:		1		6	0									
Part Number: M6061T6S.040 Revision: 6061-T6 .040 Sheet														
100	Receive sf	S025312	169596	0 sf	0		MAT021		Stock	12/19/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		6	0									

Plex 1/12/2018 7:46 AM Dart.Lajeunesse.Marie